

**WHAT IS CLAIMED AS NEW AND DESIRED TO BE SECURED BY LETTERS PATENT
OF THE UNITED STATES IS:**

1. A toner comprising:

a binder resin comprising a urea-modified polyester resin;

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a colorant master batch comprising:

a colorant;

a resin; and

a pigment dispersant,

10 wherein the toner is prepared by a method comprising:

dissolving or dispersing a toner composition comprising
a modified polyester resin capable of forming the urea-modified
polyester resin and the colorant master batch in an organic
solvent, thereby forming a liquid;

15 dispersing the liquid in an aqueous medium comprising resin
fine particles while reacting the urea-modified polyester resin
with at least one of a crosslinker and an elongation agent to
provide particles; and

washing the particles after removing the organic solvent
20 therefrom.

2. The toner of Claim 1, wherein the pigment dispersant
is present in an amount of 1 to 30 % by weight based on total
weight of the colorant.

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3. The toner of Claim 1, wherein the colorant master batch
further comprises a pigment dispersion auxiliary agent.

4. The toner of Claim 1, wherein the colorant has a number-average particle diameter of not greater than $0.5\ \mu\text{m}$, and wherein a ratio of particles of the colorant having a number-average particle diameter not less than $0.7\ \mu\text{m}$ is not greater than 5 % by number.

5. The toner of Claim 1, wherein the toner composition further comprises an unmodified polyester resin, and wherein a weight ratio (i/ii) of the urea-modified polyester resin (i) to the unmodified polyester resin (ii) is from 5/95 to 25/75.

6. The toner of Claim 1, further comprising a wax.

7. The toner of Claim 1, wherein the toner has a glass transition temperature of from 40 to $70\ ^\circ\text{C}$.

8. The toner of Claim 1, wherein the toner has a volume-average particle diameter of from 4 to $8\ \mu\text{m}$, and wherein a ratio (D_v/D_n) of the volume-average particle diameter (D_v) to the number-average particle diameter (D_n) of the toner is not greater than 1.25.

9. The toner of Claim 1, wherein the toner has an average circularity of from 0.94 to 1.00.

10. The toner of Claim 1, wherein the resin fine particles

have an average particle diameter of from 5 to 500 nm.

11. A developer comprising the toner according to Claim 1.

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12. An imaging forming method comprising:

charging a photoreceptor;

irradiating the photoreceptor to form an electrostatic latent image thereon;

10 developing the electrostatic latent image with a toner according to Claim 1 to form a toner image on the photoreceptor; transferring the toner image onto a transfer sheet; and fixing the toner image on the transfer sheet.

15 13. A toner container containing the toner according to Claim 1.

14. An image forming apparatus comprising:

a charger for charging a photoreceptor;

20 an irradiator for irradiating the photoreceptor to form an electrostatic latent image thereon;

an image developer for developing the electrostatic latent image with a toner according to Claim 1 to form a toner image on the photoreceptor;

25 a transferer for transferring the toner image onto a transfer sheet; and

a fixer for fixing the toner image on the transfer sheet.

15. A detachable process cartridge with an image forming apparatus comprising:

a photoreceptor; and

5 a member selected from the group consisting of chargers, image developers and cleaners,

wherein the image developers comprise a developer comprising the toner according to claim 1.